Work Order ID 125221

125221

Tuesday, October 07, 2014 10:38:27 AM

Item ID: D5012-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Spacer

Start Date: 10/06/14 **Start Qty:** 20.00 *20* **Cust Item ID:**

Required Date: 10/06/14 **Req'd Qty:** 20.00 *20* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-10-08 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D5012 / C									
100		0.00							
100	Hardinge CNC LATHE SMALL					20	0		MJP 14/10/09
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1-Turn D5012 as per Folio DWG REV: AA FOLIO REV: C DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						20	0		MJP 14/10/09
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D5012-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Spacer
Start Date: 10/06/14 **Start Qty:** 20.00 *20* **Cust Item ID:**
Required Date: 10/06/14 **Req'd Qty:** 20.00 *20* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				20	0		DAS 40 9-89
120 QC Quality Control	**Memo**	0.00							14/10/10
130	Identify as per dwg & Stock Location: ST 130	0.00				20		MLJ	14-10-10
130 Packaging Packaging	**Memo**	0.00							
140	QC21- Final Inspection - Work Order Release	0.00							14/10/14
140 QC Quality Control	**Memo**	0.00							

MLJ 14-10-10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
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☐ Positioned Wrong
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Tuesday, October 07, 2014 10:38:27 AM

Work Order ID: 125221 *125221*

Parent Item: D5012-1 *D5012-1*

Parent Item Name: Spacer

Start Date: 10/06/14 **Required Date:** 10/06/14

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP REV:A NEW ISSUE 13-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.500		Purchased	No				f	103.3421	**	1		14/10/09	

MDELRINR0.500

Delrin Round Bar .50" color: black

Location	Loc Qty	Loc Code	
MAT039	103.342104		
123698	2.473684		
m126369	100.86842		0,725

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

DART AEROSPACE

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	12522 1
Description: Spacer	Part Number:	D5012-1
Inspection Dwg: D5012 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

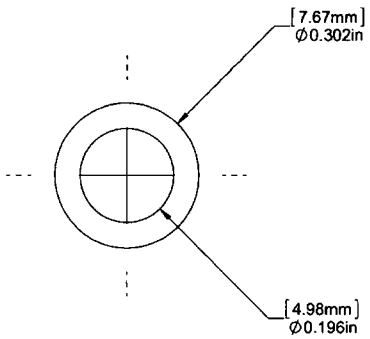
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.302	+0.006/-0.001	0.300	✓		MJP-01	mic
Ø0.196	+0.005/-0.001	0.196	✓		MJP-04	vern
0.203	+0.002/-0.003	0.203	✓		MJP-01	mic

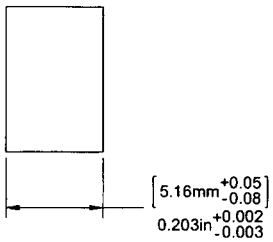
Measured by:	[signature]	Audited by:	DAS 40 9-89	Preliminary Approval:	
Date:	14/10/09	Date:	14/10/10	Date:	

Rev	Date	Change	Revised by	Approved
A	14.09.25	New Issue	KJ	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 125221 MCJ
14-10-08





RELEASED
2014 -07- 28

D5012-1 SPACER

NOTES:
1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5012-1", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING A REMOVABLE TAG, PER QSI 044 METHOD 6.6
C 7) WEIGHT: 0.0005 lbs (0.0002kgs)

REV.	DESCRIPTION	BY	DATE
C	REVISED D5012-1 SPACER DIMENSION (ZN B3-1, ZN B5-1). UPDATED NOTE 7 (ZN A8-1)	AK	14.07.14
B	REVISE NOTE 6) (ZN A8-1)	AK	14.06.05
A	NEW ISSUE	DC	13.11.22

APPROVED

DESIGN	DC
DRAWN	AK
CHECKED	RF
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	14.07.14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5012 REV. C
SHEET 1 OF 1
TITLE SPACER
SCALE NTS

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